



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-145
Job Sheet 167765



Part No: D4634-145 Job Qty: 1 ea
Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/6/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/17	0.00	0.00	Start Up Small Fab		D.M.L 17-12-23
110	Small Fab	1 pcs		12/8/17	0.00	1.47	Small Fab		D.M.L 17-12-23
120	QC	1 pcs		12/8/17	0.00	0.00	QC5		D.M.L 17-12-23
130	Packaging	1 pcs		12/8/17	0.00	0.00	Packaging3		D.M.L 17-12-14
140	QC21-SA	1 Ea		12/8/17	0.00	0.00	QC21		D.M.L 17-12-14

Part Op 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Descriptions: Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/29 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location: TH
140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5 - 164280	1	3	0	0
	ST 107 D4636-5 164519	1	290	0	0
	01 D4647-1 F165218	1	33	0	0
	04 D4664-5 - 5001407	6	27	0	0
	04 D4712-1 5008996	1	1	0	0
	ST 520 D4732-17-5007456 SC98A	1	0	0	0
	05 D4732-23 - 5008998	1	1	0	0
	05 D4732-27 - 5020428	1	1	0	0
	QC - D5021-5 - 5017026	1	1	0	0
	ST 520 MPNY-750S-9-C FM 130423-1	9	560	0	0
	ST 312 MS20426AD3-4 FM 134294	4	6,968	0	0
	ST 311 MS20426AD4-6 FM 138621	2	2,218	0	0
	ST 300 MS21059L08.5006910	2	156	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part: _____ NCR: _____ Date: _____ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	DISPOSITION Mfg Date: 12/13/17 Job No: 167765 D4634 - 145 Start up Operation	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table> QTY Effective : _____ Disposition MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																
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Envir: _____ D: _____ Equip: _____ Hand: _____ Internal T: _____ Tribal Kn: _____ DART AEROSPACE S021235 Aft, Center Ceiling Replacement Panel Assembly PART NO: D4634 - 145 Revision: Operation: Change No:	FAULT CATEGORY <table style="width: 100%;"> <tr> <td>☐ Temperature/Cure</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>			☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Countersink	☐ Off-set	☐ Drawing	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
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Substation: _____ Past Expiry Date: _____ Misidentified: _____	Process Improvement: _____ Manufacturing Process: _____ Past Due: _____ OTHER: _____																																